

Date: Thursday, 5/10/2007 2:25:27 PM
 /User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT ASSEMBLY
Job Number : 32278	
Estimate Number : 10732	
P.O. Number : <i>N/A</i>	Part Number : D23241
This Issue : 5/10/2007	Drawing Number : D2324 REV. C
S.O. No. : <i>N/A</i>	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : C
First Issue : <i>N/A</i>	Material : <i>N/A</i>
Type : SMALL /MED FAB	Due Date : 5/30/2007
Previous Run : 32065	Qty: 20 Um: Each
Written By : <i>[Signature]</i>	
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: E 03.02.28 Reformat, Incorporated D2324-3 & D2324-5 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	32278A	STOP
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Comment: Sub-Component STOP

D2324-3 B *31270 A(x9)* *B32353 (x11)* ✓

2.0	32278B	STRAP
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Comment: Sub-Component STRAP

D2324-5 B *32065 B (x2)* *B30139B (x34)* ✓

3.0	AN312A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt *M18310 (x28)* *M100188 (x12)* ✓

4.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Washer *M104885 (x80)* ✓

5.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut *M103691 (x40)* ✓

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2324.

m 07/07/19
x20
m 07/07/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/01/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

all bolts.
07/07/20 (20)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/07-07-26 (20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/07/27 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

07/07/27 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/27 (20)

Job Completion



U 07/07/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

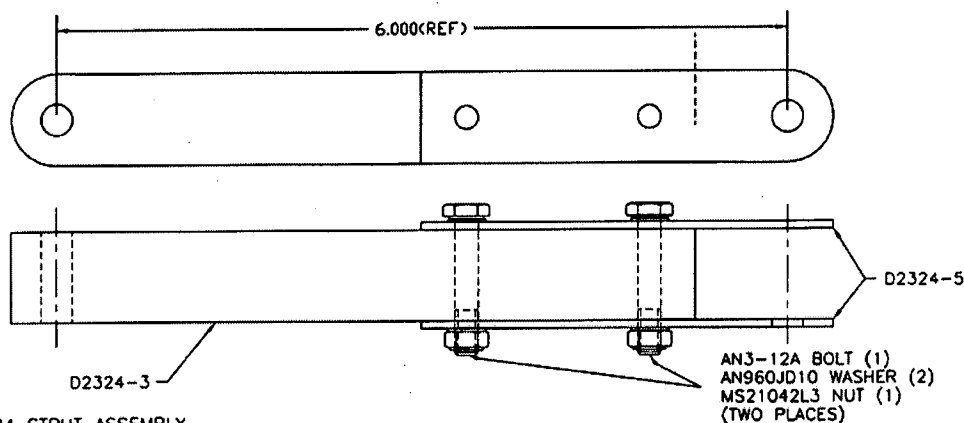
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

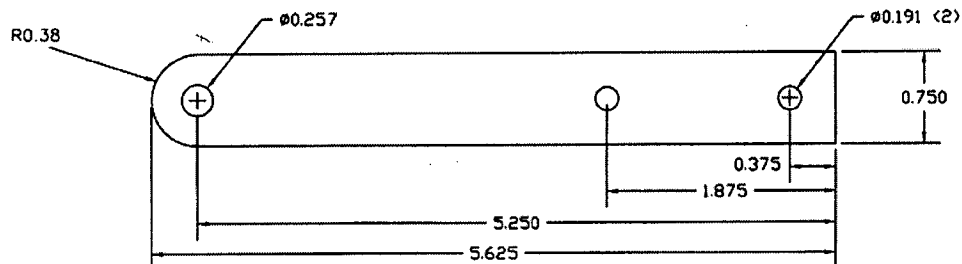
RELEASED

04.12.16 *[Signature]*



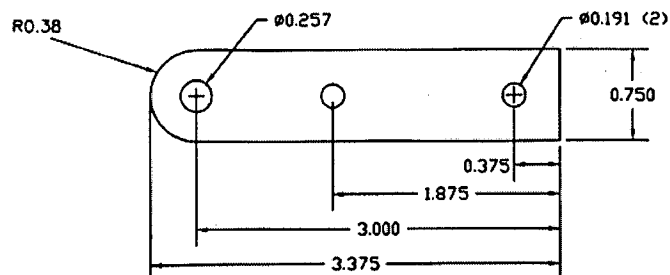
D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32278